Date: Wednesday, 3/7/2007 8:07:35 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L UTILITY BASKET - ~~UNDER REVIEW~~
Job Number	: 31009		
Estimate Number	: 11272		
P.O. Number	: N/A	Part Number	: D206540011
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: N/A ~~UNDER REVIEW~~ 07.03.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: I
Previous Run	: 27160	Material	: N/A
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.16		
Comment	: Est Rev:I Revised per Rev I 05-12-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD206-540-011 CHG ~~004~~ 005

Seq. #:	Machine Or Operation:	Description :
2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

Seq. #:	Machine Or Operation:	Description :
3.0	31009A	206L BASKET BASE - UNDER REVIEW

Comment: Sub-Component 206L BASKET BASE
D2252-041 B 31009A.

Seq. #:	Machine Or Operation:	Description :
4.0	31009B	206L BASKET LID - UNDER REVIEW

Comment: Sub-Component 206L BASKET LID
D2252-043 B B31009B

Seq. #:	Machine Or Operation:	Description :
5.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B32572

7/8/21 SP

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date:, Wednesday, 3/7/2007 8:07:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009 **Part Number:** D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2022-101 SPACER B30543 SP

Seq. #:	Machine Or Operation:	Description :
7.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B32573 SP

Seq. #:	Machine Or Operation:	Description :
8.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B31486 SP

Seq. #:	Machine Or Operation:	Description :
9.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B32574 SP

Seq. #:	Machine Or Operation:	Description :
10.0	D2931	Bumper

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4. D2931 Bumper B21139 SP SP

Seq. #:	Machine Or Operation:	Description :
11.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS20600AD4W3 Rivet M10475 7/8/2/SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 3/7/2007 8:07:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009
Part Number: D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M102140

SP

Seq. #:	Machine Or Operation:	Description :
13.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-24A	Bolt	M101938

SP

Seq. #:	Machine Or Operation:	Description :
14.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M104093

SP

Seq. #:	Machine Or Operation:	Description :
15.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M102959

SP

Seq. #:	Machine Or Operation:	Description :
16.0	AN517A	Bolt

Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
6	AN5-17A	Bolt	5 M104016 (1) M104885

SP

Seq. #:	Machine Or Operation:	Description :
17.0	AN960JD416	Washer

Comment: Qty.: ~~4.0000~~ Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2 ~~4~~	AN960JD416	Washer	M104215

PTO

7/8/21 SP

07.08.22

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.08.22	17.0	QTY (4) AN960416 WASHER CHANGE TO QTY. (2) ADD QTY (2) AN960JD416L WASHER M105078 TO BE UPDATED AS NEW RECORDS For this one only. waiting for ECN	[illegible]	07-08-22		07.08.22	07/08/22

Part No: ________ PAR #: ______ Fault Category: ________ NCR: Yes No DQA: _____ Date: ________

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009 | Part Number: D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M104156 SP

Seq. #:	Machine Or Operation:	Description :
19.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344 SP

Seq. #:	Machine Or Operation:	Description :
20.0	AN960JD8	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD8 Washer M104537 SP

Seq. #:	Machine Or Operation:	Description :
21.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M104936 SP

Seq. #:	Machine Or Operation:	Description :
22.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L4 Nut (or -4) M102552 SP

Seq. #:	Machine Or Operation:	Description :
23.0	D2258170	Placard - 170 lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
1 D2258-170 PLACARD B/6266 2/8/21 SP

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009 **Part Number:** D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M104118 7/8/21 SP

Seq. #:	Machine Or Operation:	Description :
25.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Dart Logo label large
Batch: B22553 4 X D3396-3 B32784 per DSJ 9361

Seq. #:	Machine Or Operation:	Description :
26.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-540 MF 07-08-22

Seq. #:	Machine Or Operation:	Description :
27.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP ER 07/08/22

Seq. #:	Machine Or Operation:	Description :
28.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Seq. #:	Machine Or Operation:	Description :
29.0	D2249041	Fitting Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 d2249-041 bracket B31609

Seq. #:	Machine Or Operation:	Description :
30.0	D2259	Label

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit
1 D2259 Placard B10671 7/8/21 SP

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009 **Part Number:** D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D2525	Spacer Kit
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2525 Spacer kit B27554 SP	
32.0	D2526	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2526 Bushing B23139 SP	
33.0	D2537	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2537 BUSHING B32574 SP	
34.0	D2748	Clevis
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 D2748 Clevis B27560 SP	
35.0	D27495	Strut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-5 Strut B24137 SP	
36.0	D27497	Strut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Packing Kit 1 D2749-7 Strut B26887 SP	
37.0	AN421A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit 2 AN4-21A Bolt M11695 7/8/29 SP	

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 3/7/2007 8:07:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009 | **Part Number:** D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
38.0	AN45A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit
8 AN4-5A Bolt M100857 SP

Seq. #:	Machine Or Operation:	Description :
39.0	AN412A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN4-12A Bolt M104547 SP

Seq. #:	Machine Or Operation:	Description :
40.0	AN517A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN5-17A Bolt M104016 SC

Seq. #:	Machine Or Operation:	Description :
41.0	AN960JD416	Washer

Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
12	AN960JD416	Washer	M104315 SO

Seq. #:	Machine Or Operation:	Description :
42.0	AN960JD516	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 AN960JD516 Washer M104156 SP

Seq. #:	Machine Or Operation:	Description :
43.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21042L4	Nut (or -4)	M102552

7/8/21 SP

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206L UTILITY BASKET - UNDER REVIEW

Job Number: 31009
Part Number: D206540011

Job Number:

Seq. #:	Machine Or Operation:	Description :
44.0	MS21042L5	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Packing Kit
2 MS21042L5 Nut
M/D 4/11/8
1/8/21 SP

Seq. #:	Machine Or Operation:	Description :
45.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

J 21AUG'24 (V)

Comment: INSPECT 100% KITS FOR COMPLETENESS

Seq. #:	Machine Or Operation:	Description :
46.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D206-540-011
Location:__________
PPP Rev: __________

Seq. #:	Machine Or Operation:	Description :
47.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Add 4x D3396-3 B 32784
per DSI 9361

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:35 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L UTILITY BASKET - ~~UNDER REVIEW~~
Job Number	: 31009		
Estimate Number	: 11272		
P.O. Number	:	Part Number	: D206540011
This Issue	: 3/7/2007 S.O. No. :	Drawing Number	: N/A ~~UNDER REVIEW~~ 07.03.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: I
Previous Run	: 27160	Material	:
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.16		
Comment	: Est Rev:I Revised per Rev I 05-12-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD206-540-011 CHG~~004~~ 005 07.03.16

2.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

3.0	31009A	206L BASKET BASE - UNDER REVIEW

Comment: Sub-Component 206L BASKET BASE
D2252-041 B______

4.0	31009B	206L BASKET LID - UNDER REVIEW

Comment: Sub-Component 206L BASKET LID
D2252-043 B______

5.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	D2332-041	Prop Ass'y	______

REFERENCE ONLY

Form: mprocess

Date: Wednesday, 3/7/2007 8:07:52 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET BASE ~~- UNDER REVIEW~~
Job Number	: 31009A		
Estimate Number	: 11273		
P.O. Number	: N/A	Part Number	: D2252041
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D2252 ~~UNDER REVIEW~~ 07.03.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 27160A	Material	: N/A
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.16		
Comment	: Est Rev: Revised as per Rev E 05-12-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part#	Description	Batch
5	D3166-1	Hoop	B32067

Seq. #:	Machine Or Operation:	Description :
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M104980 PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.
Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
4.0	D22531	Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2253-1	Gusset	B27563

PD 07-08-09

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L BASKET BASE - UNDER REVIEW

Job Number: 31009A **Part Number:** D2252041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D23273	Spacer Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch		
1	D2327-3	Bushing	B30876	PD	07-08-09

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch		
4	D2581	Mounting Chanel	B32066	PD	07-08-09

Seq. #:	Machine Or Operation:	Description :
7.0	D2254	Gusset for D206bskt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch		
2	D2254	Lug	B23421	PD	07-08-09

Seq. #:	Machine Or Operation:	Description :
8.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch		
2	D2232-3	HINGE	B31784	PD	07-08-09

Seq. #:	Machine Or Operation:	Description :
9.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)
Pick:

Qty	Part Number	Description	Batch		
32 sf	M304EX0.75-16F	Expanded Metal	H104905	PD	07-08-09

Seq. #:	Machine Or Operation:	Description :
10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252using Welding Table and corner JigDeburr as required
A/R SS ROD Batch: H102756

PD 07-08-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes (No) DQA: [illegible] Date: 07/09/07

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:07:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 206L BASKET BASE - UNDER REVIEW

Job Number: 31009A **Part Number:** D2252041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	07/08/20
12.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/08/20
13.0	POWDER COATING m/105068	POWDER COATING 07/08/21 (1)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 PRESS WASH	07-08-21
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	mf 07-08-22
15.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA 31009	mf 07-08-22 (1)
16.0	QC21	FINAL INSPECTION/W/O RELEASE (1)
	Comment: FINAL INSPECTION/W/O RELEASE	07/08/27

Job Completion

07.08.27

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2252 — REV. E — SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS

REV	DATE	DESCRIPTION
C	95.12.11	RE-DRAWN
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19

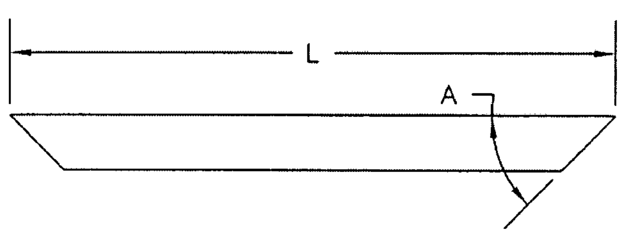
RELEASED 05.11.26

Qty -041	Qty -043	Part Number	Description	L	A
X		**D2252-041**	**BASKET ASSEMBLY**		
	X	**D2252-043**	**LID ASSEMBLY**		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

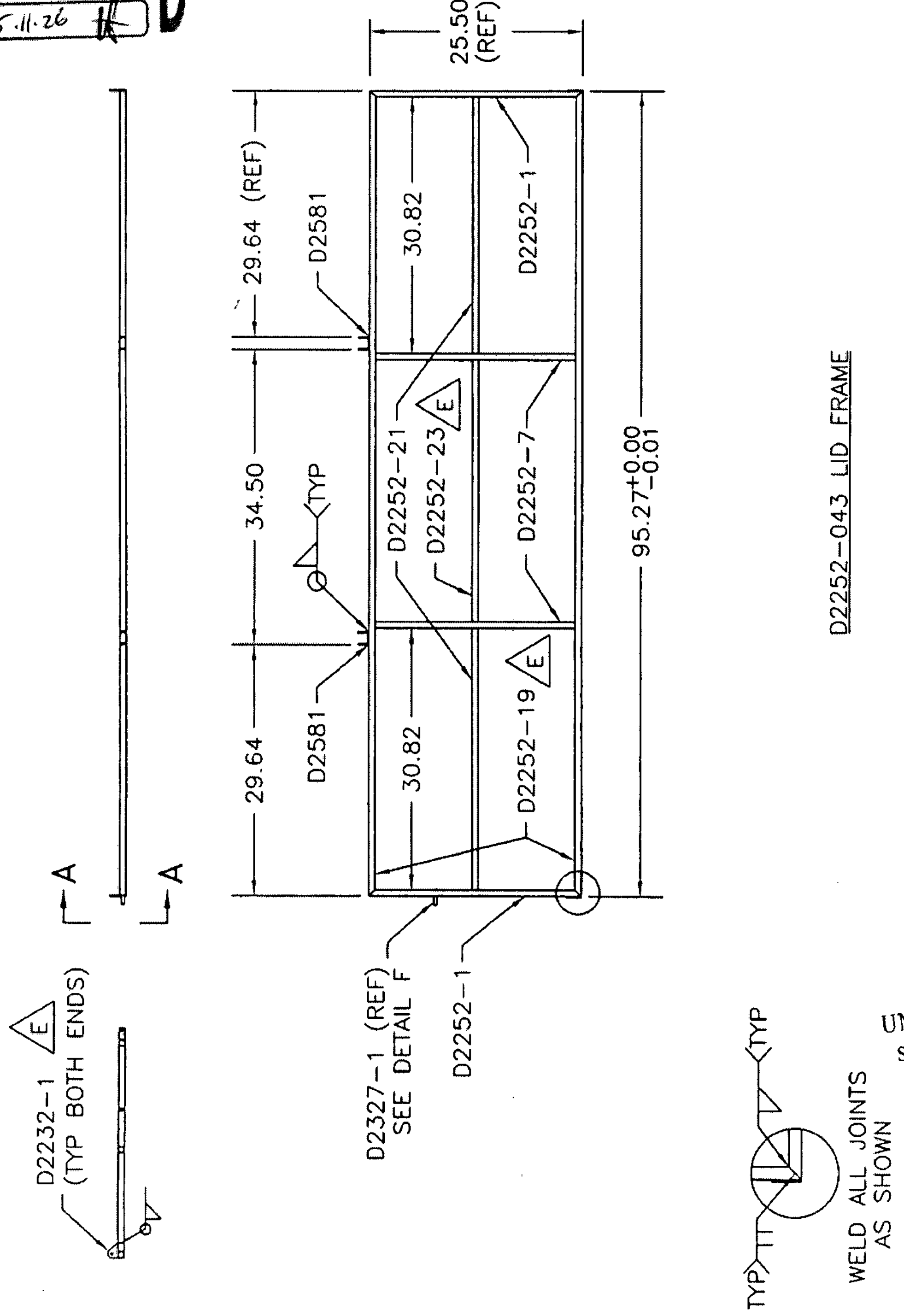
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WORK ORDER NO. 31008 A



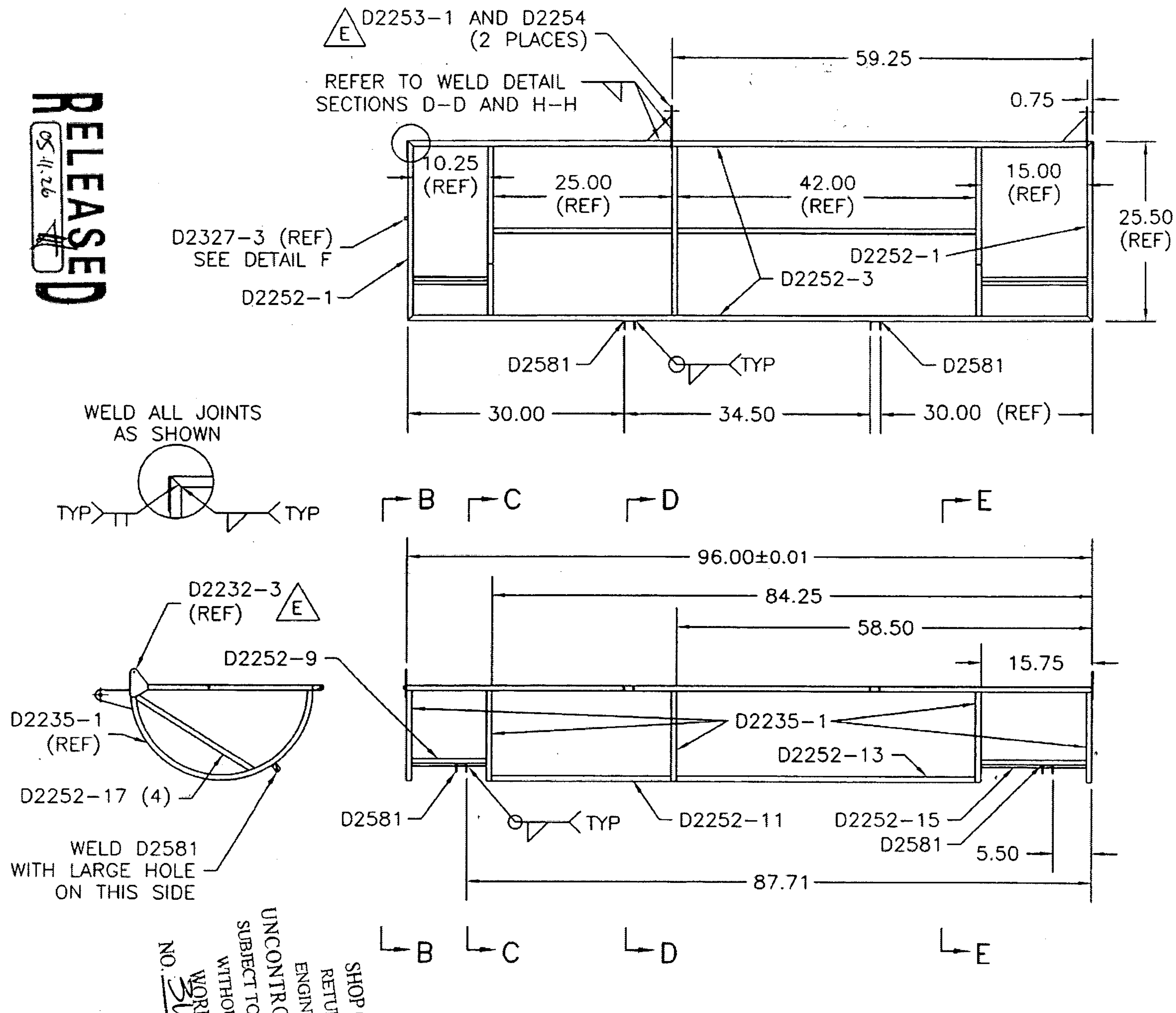
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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2252	REV. E SHEET 2 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS

RELEASED 05.11.26



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WORK ORDER
NO. 31009A



D2252-041 BASKET FRAME

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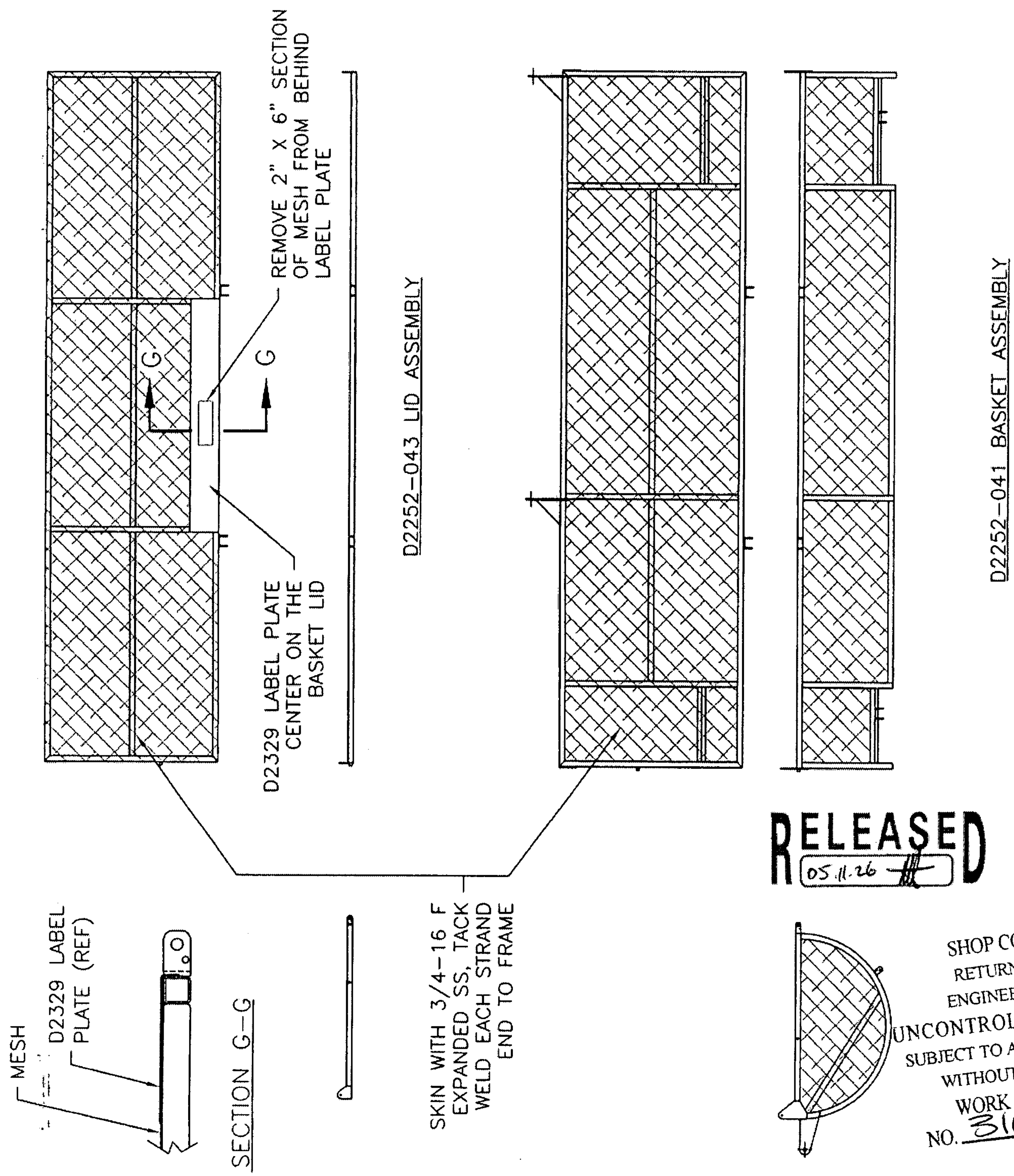
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WORK ORDER NO.

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2252 — REV. E
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SHEET 3 OF 5
		SCALE NTS

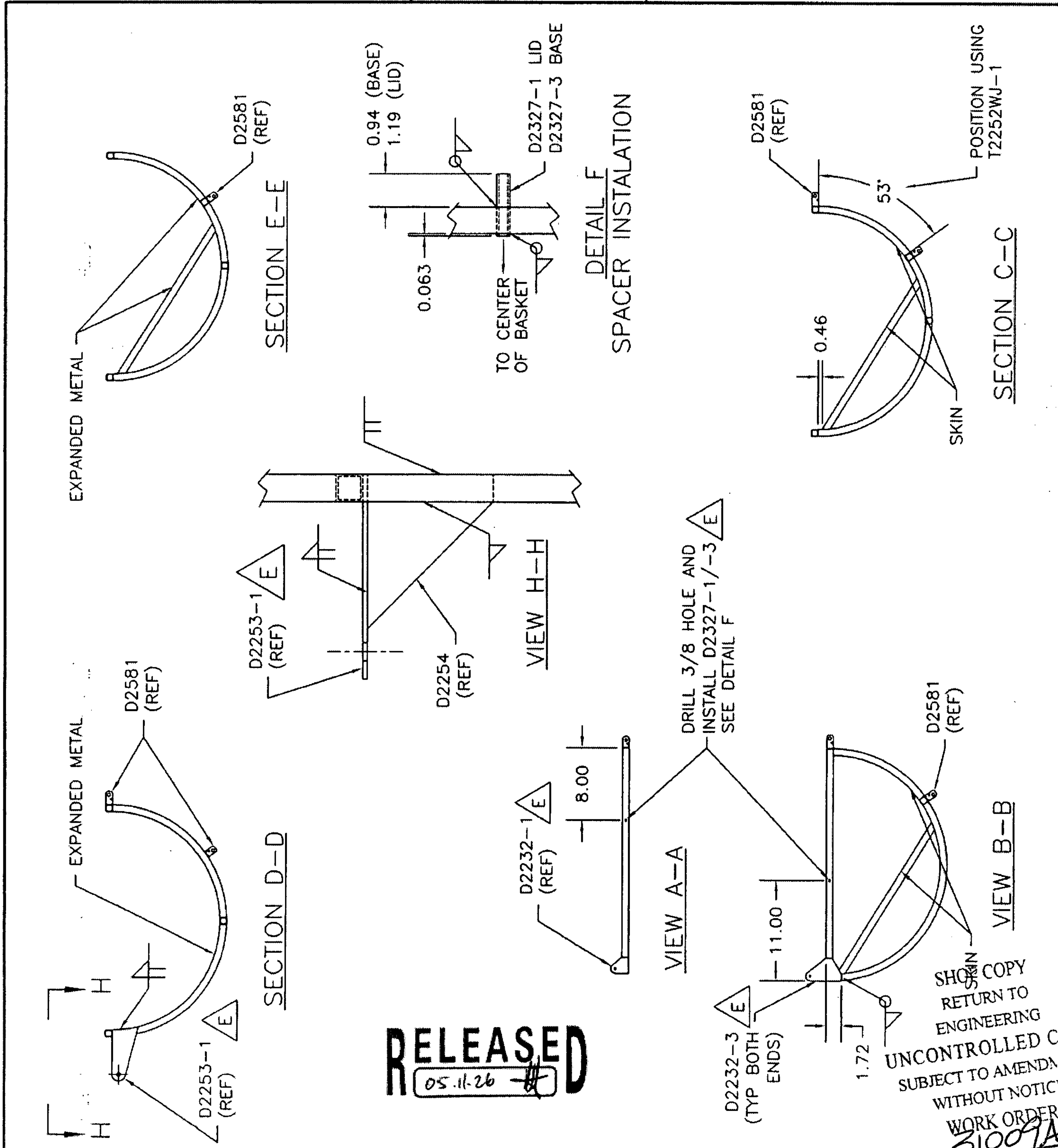
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CHECKED [initials]	APPROVED [initials]	DRAWING NO. D2252	REV. E SHEET 4 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS



RELEASED 05.11.26

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WORK ORDER NO. 31009 A

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KE	MB	
CHECKED	APPROVED	DRAWING NO. D2252 — REV. E — SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS



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WORK ORDER NO 31009A

Dart Aerospace Ltd.

Date: Wednesday, 3/7/2007 8:08:05 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET LID ~~UNDER REVIEW~~
Job Number	: 31009B		
Estimate Number	: 11274		
P.O. Number	: N/A	Part Number	: D2252043
This Issue	: 3/7/2007 S.O. No. : N/A	Drawing Number	: D2252 ~~UNDER REVIEW~~ 07.03.16
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 27160B	Material	: N/A
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.16		
Comment	: Est Rev: REVISED AS PER REV E 05-12-06 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s)
3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M104980 PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2252-1-3-9 as per Dwg D2252

2-Drill hole in D2252-1 as per Dwg D2252

3-Deburr & Remove all Markings from Material PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
3.0	D2329	Label Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2329	Label Plate	B29936

PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
4.0	D23271	Spacer Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2327-1	Bushing	B31693

PD 07-08-09

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 3/7/2007 8:08:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 206L BASKET LID - UNDER REVIEW

Job Number: 31009B
Part Number: D2252043

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	HINGE	B29535

PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Chanel	B32066

PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)
Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	H104905

PD 07-08-09

Seq. #:	Machine Or Operation:	Description :
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig
Deburr as required
A/R SS ROD Batch: H102756

PD 07-08-15

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — 07/08/20

Seq. #:	Machine Or Operation:	Description :
10.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP — 07/08/20

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING

M105068 FX 07/08/21 (1)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 — PRESS WASH BR / FX. 070821

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/08/27

QA: N/C Closed: ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:08:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 206L BASKET LID - UNDER REVIEW

Job Number: 31009B | **Part Number:** D2252043

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	mf 07-08-22
13.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA	31009 u mf 07-08-22 (1)
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(2) 07/08/27

Job Completion

07/08/27

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED [initials]	APPROVED [initials]	DRAWING NO. D2252 — REV. E — SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS

DART

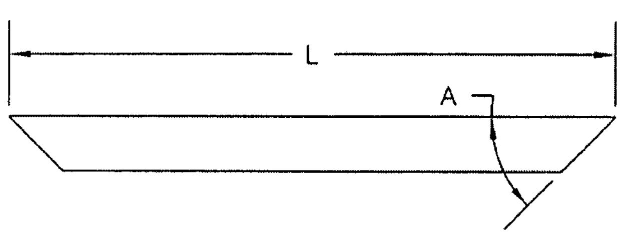
C	95.12.11	RE-DRAWN
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19

RELEASED 05.11.26

Qty -041	Qty -043	Part Number	Description	L	A
X		**D2252-041**	**BASKET ASSEMBLY**		
	X	**D2252-043**	**LID ASSEMBLY**		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

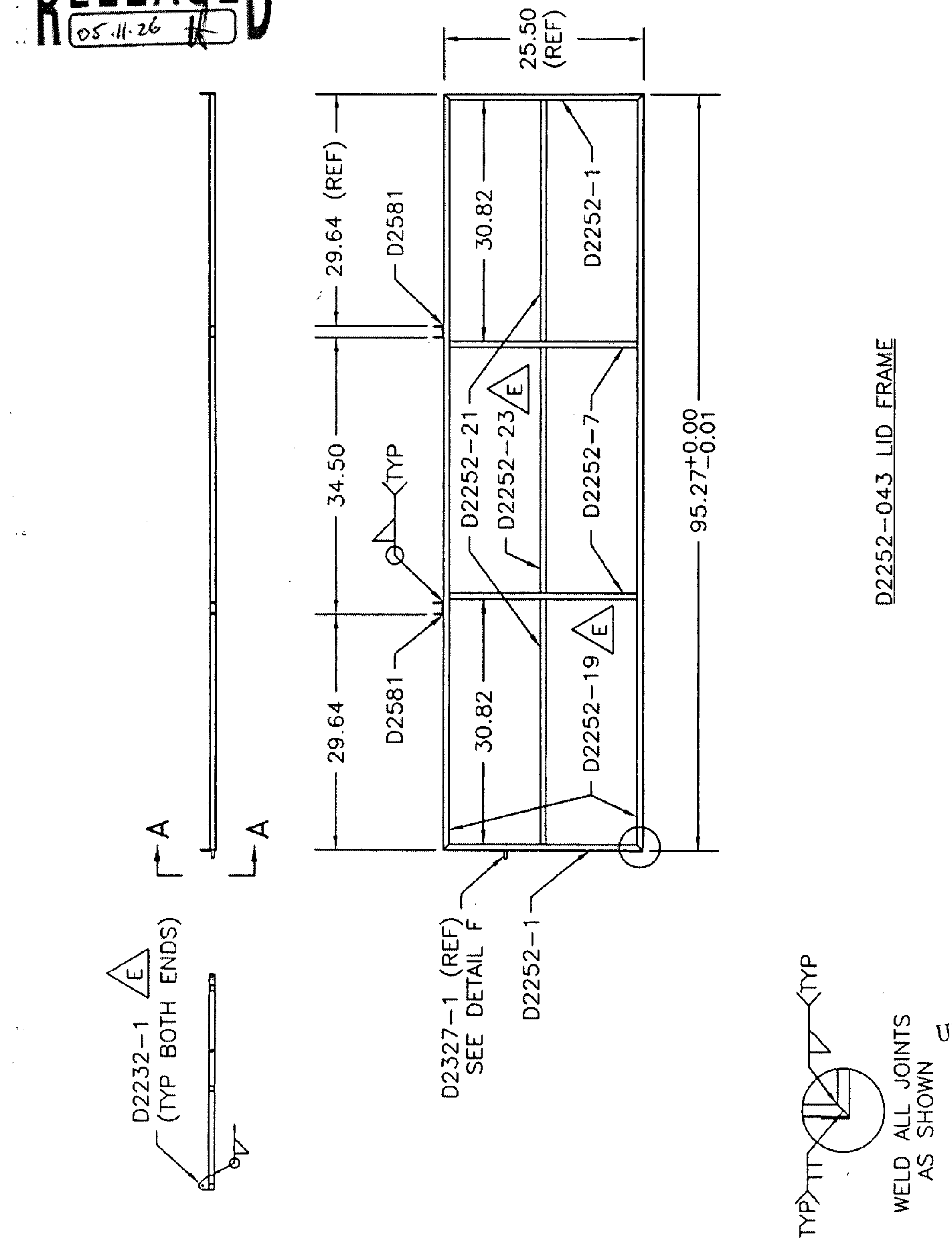


CUT SIZE DETAIL

DART

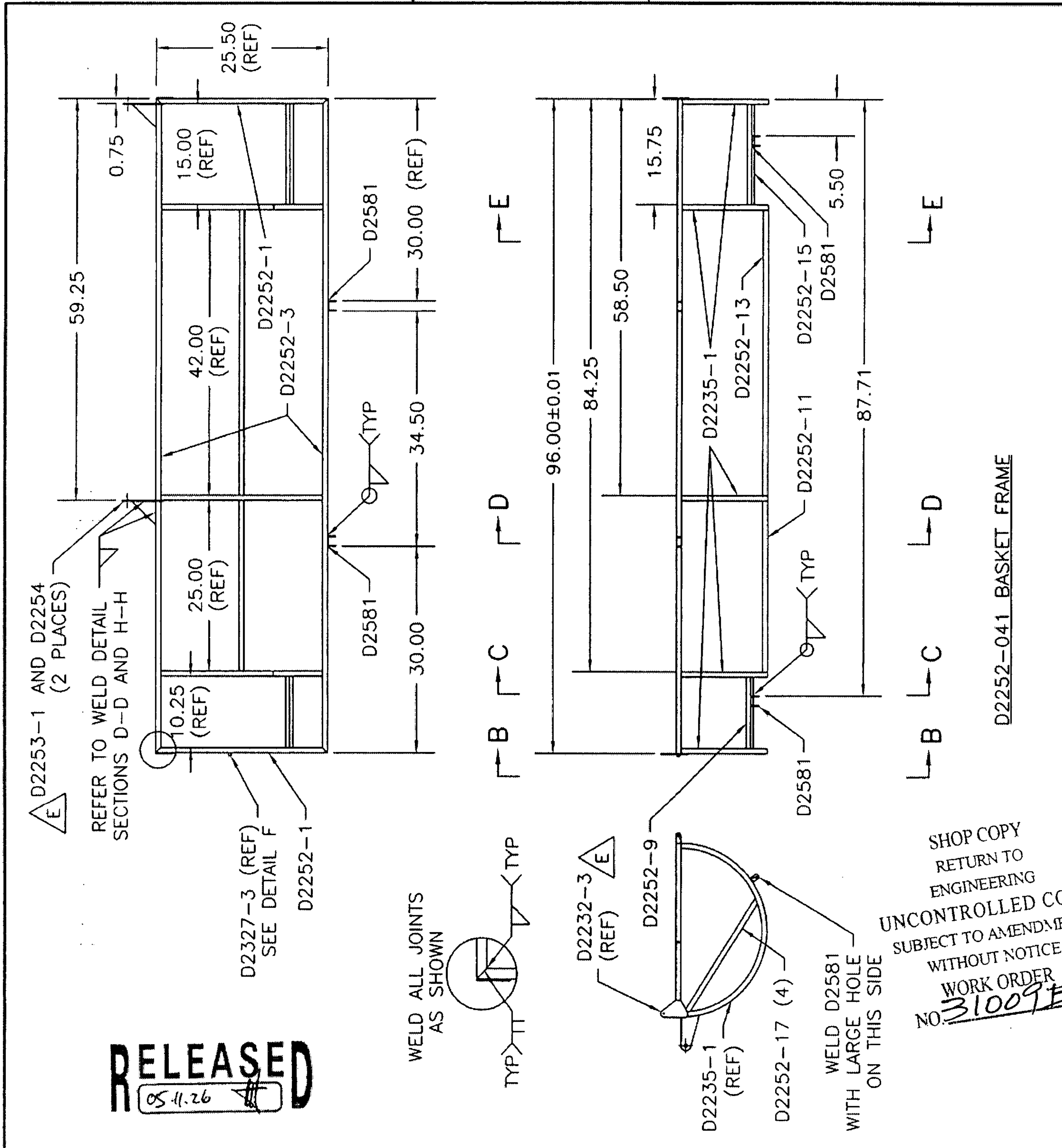
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KE	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2252 — REV. E — SHEET 2 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS

RELEASED 05.11.26

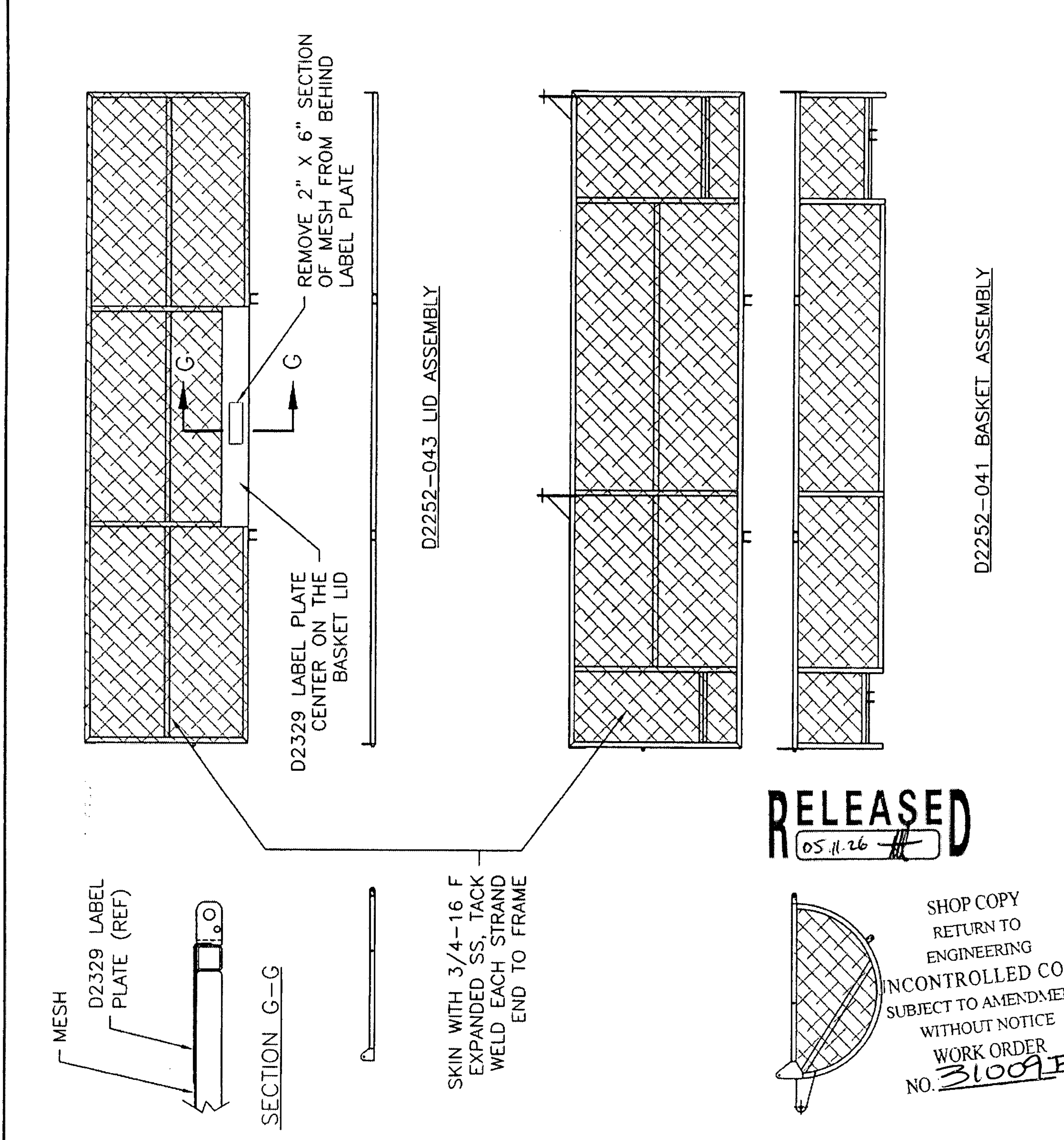


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WORK ORDER NO. 31009B

DESIGN	DRAWN BY	DART AEROSPACE LTD
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CHECKED	APPROVED	DRAWING NO. D2252 — REV. E — SHEET 3 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	MB	
CHECKED	APPROVED	DRAWING NO. D2252 — REV. E — SHEET 4 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L) — SCALE NTS



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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2252	REV. E SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS

